

ASA Please

Work Order ID 63179

October 22, 2010 11:38:28 AM



Page 1

Item ID: D3948-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate, Anchor

Start Date: 10/22/10 Start Qty: 3.00



Cust Item ID:

Required Date: 10/26/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: W

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3948

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3948-1

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B10-10-25

(5)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-10-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63179

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Page 2

Item ID: D3948-041

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Cust Item ID:

Required Date: 10/26/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

S 10/10/26

X5

130



Small Fab

Small Fab

Memo

1- countersink holes as per dwg

2- deburr if necessary

0.00

0.00

E 10/10/26 X5

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/10/26

X5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 4

Accept



Setup Start

Abstract

Stop

Abstract

[illegible]**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

[illegible]

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

[REDACTED]

Small Fab

Memo

0.00

Small Fab

INSTALL NUT PLATES AS PER DWG

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

0.00

[illegible]

Packaging

Identify as per dwg & Stock Location: FOU

Memo

0.00

Packaging

Work Order ID 63179

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Page 5

Item ID: D3948-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate, Anchor

Start Date: 10/22/10 Start Qty: 3.00



Cust Item ID:

Required Date: 10/26/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/27 *[Signature]**mf*
10-10-27

Picklist Print

October 22, 2010 11:38:26 AM

Page 1

Work Order ID: 63179

Parent Item: D3948-041

Parent Item Name: Plate, Anchor

Start Date: 10/22/10

Required Date: 10/26/10

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

45.2340

0.1085

0.342632



6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT21

45.234

113608

45.234

MS21059L3

Purchased

No

170

Each

53.0000

2



Nut Plate

Location

Loc Qty

Loc Code

ST301

53

114718

6

115708

2

115727

45

MS20426AD3-3

Purchased

No

170

Each

4,185.000

4



Rivet

Location

Loc Qty

Loc Code

ST316

4185

19099

4173

7681

12



1310-10-25

5

13608

6

EP 10/10/26

10

12

EP 10/10/26

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

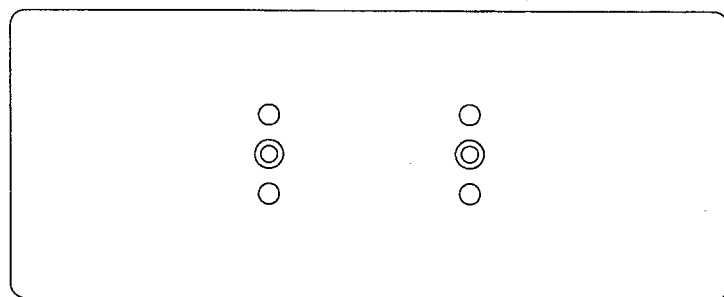
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

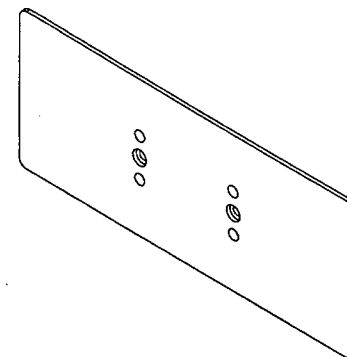
PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3948-041	PLATE, ANCHOR
2	1	D3948-1	PLATE
3	2	MS21059L3	NUTPLATE (OR MS21059-3)
4	4	MS20426AD3-3	RIVET

**D3948-041 PLATE, ANCHOR**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs



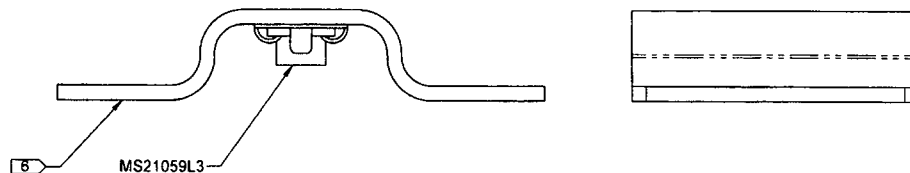
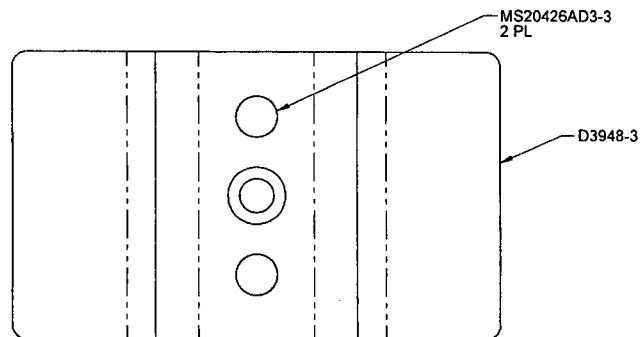
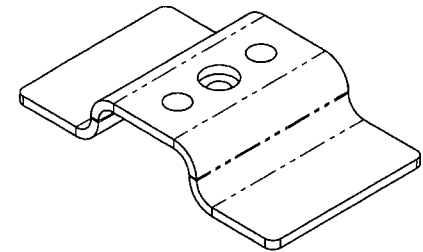
W/O 6379

RELEASED
07/06/16

B	-3F NOW MADE FROM 304 SS (ZN A8-5), 0.063 THICK WAS 0.040 (ZN A8-3, A8-5), -043/-3/-3F WIDER (ZN B6-4, B6-5)	CP	09.06.08
A	NEW ISSUE	CP	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	971	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	971		
CHECKED	2/1	DRAWING NO.	REV. B
MFG. APPR.	2/1	D3948	SHEET 1 OF 5
APPROVED	2/1	TITLE	SCALE
DE APPR.	2/1	PLATE, ANCHOR	NTS
DATE	09.06.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3948-043	PLATE, ANCHOR
2	1	D3948-3	PLATE
3	1	MS21059L3	NUTPLATE (OR MS21059-3)
4	2	MS20426AD3-3	RIVET

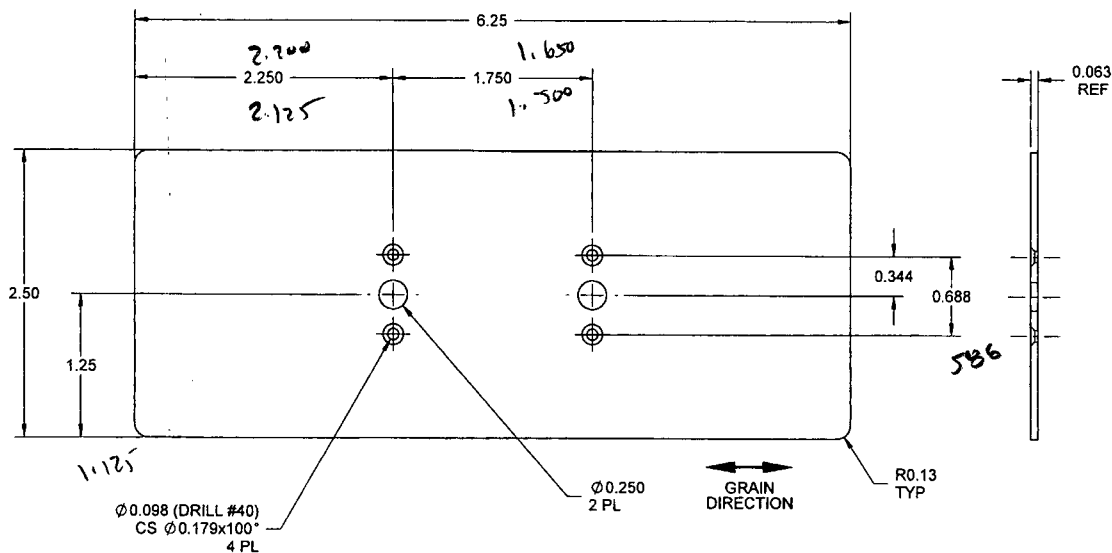
**D3948-043 PLATE, ANCHOR**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

RELEASED
07/06/17

DESIGN	901	DART AEROSPACE LTD	
DRAWN	901	HAWKESBURY, ONTARIO, CANADA	
CHECKED	901	DRAWING NO.	REV. B
MFG. APPR.	901	D3948	SHEET 2 OF 5
APPROVED	901	TITLE	SCALE
DE APPR.	901	PLATE, ANCHOR	NTS
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D3948-1 PLATE

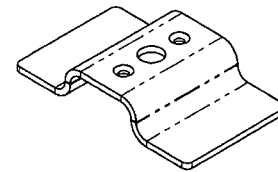
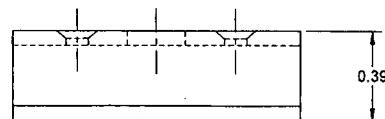
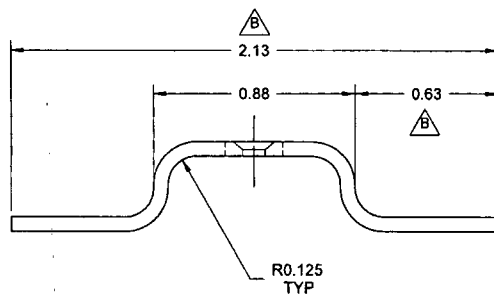
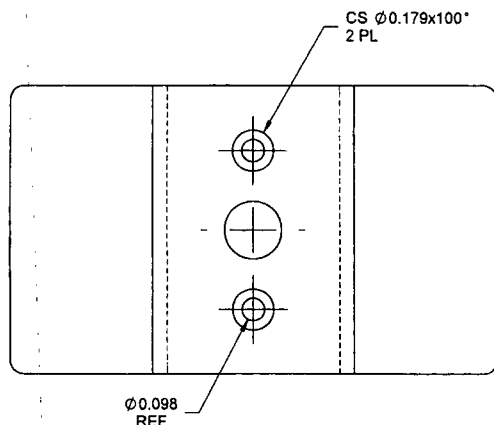
63179

RELEASED
09/06/08

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063" THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. B
MFG. APPR.	97	D3948	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	PLATE, ANCHOR	NTS
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63179

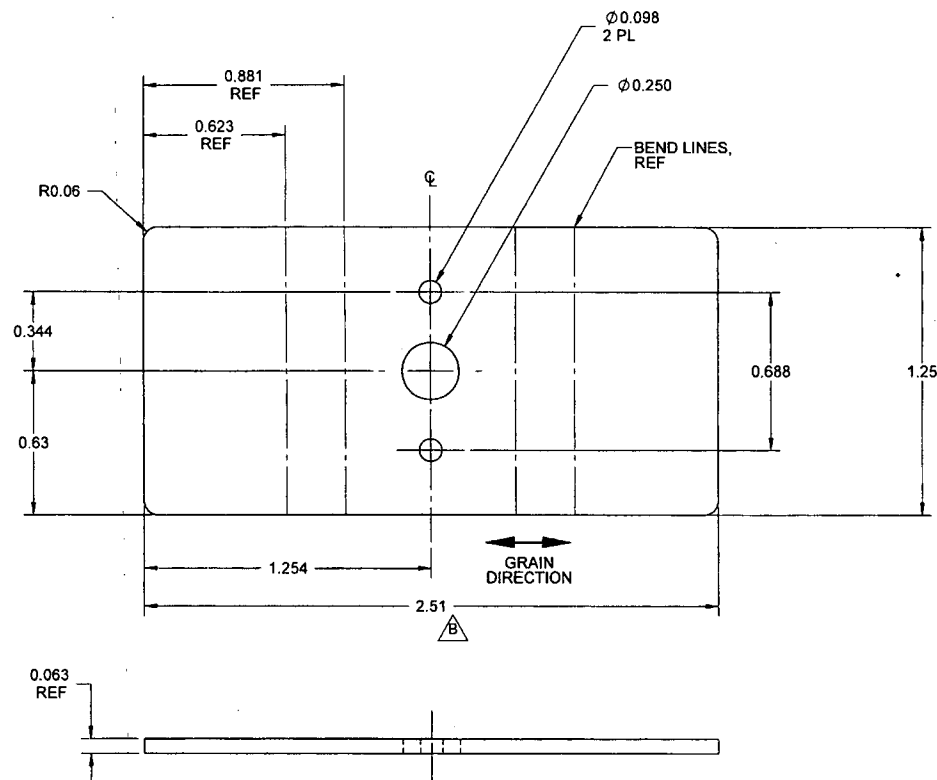
RELEASED
09/06/16

D3948-3 PLATE

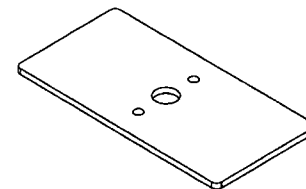
NOTES:

- 1) MATERIAL: MAKE FROM D3948-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. B
MFG. APPR.	97	D3948	SHEET 4 OF 5
APPROVED	97	TITLE	SCALE
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D3948-3F PLATE



63679

RELEASED
09/16/16

- NOTES:**
- 1) MATERIAL: AISI 304 SS SHEET 0.063" THICK (REF DART SPEC. M304S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3948	SHEET 5 OF 5
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